

Date: Friday, 8/10/2007 10:33:02 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 33869		
Estimate Number	: 12801		
P.O. Number	: <i>N/A</i>	Part Number	: D35377
This Issue	: 8/10/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31911	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/17/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>55</i> Um: Each
Comment	: Est Rev:A New Issue 07-03-12 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.1512 sf(s)/Unit Total : 7.5600 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: *M105130*

SAD 07/08/13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3537
Dwg Rev: *C*
Prog Rev: *C*

2-Deburr if necessary

SAD 07/08/14

SAD 07/08/13

55

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/13

54

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/08/13

(55) counter

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary SAD 07/08/14 K5
Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.

SAD 07/08/15 (55)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33869

Part Number: D35377

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

EN 07/08/05 (X55)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Qty Description Batch
A/R 2059B Hardcoat M105315
Weld hardcoat as per Dwg D3437

SL 07/09/05 (X55)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/07/09/06 (55)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/07/09/06 (55)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FN/04/846
Fol 07/09/07 (55)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25 07-09-08 (55)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: FE-17

Fol 07/09/11 (55)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

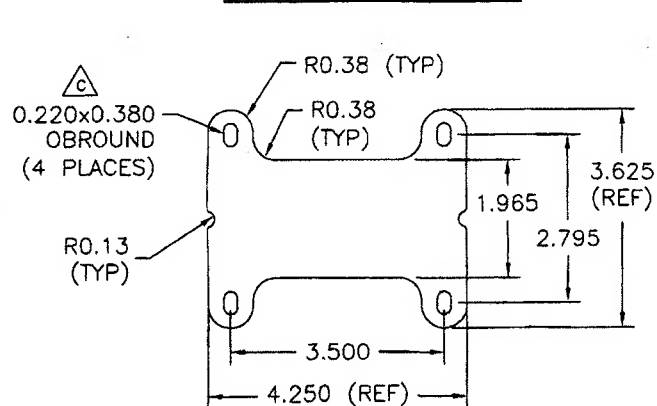
07/09/13

Job Completion

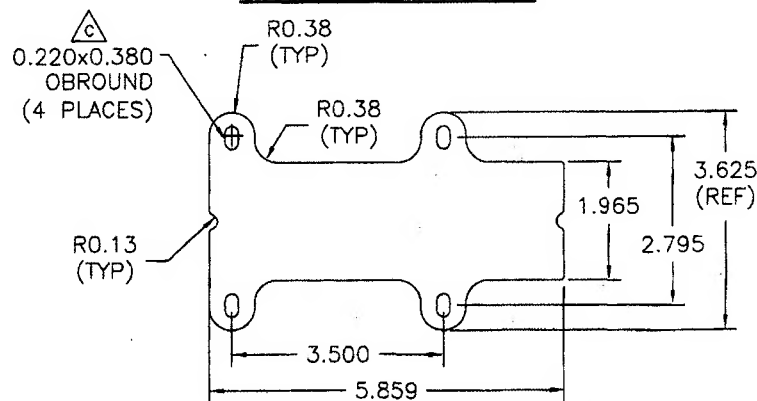


u 07-09-13

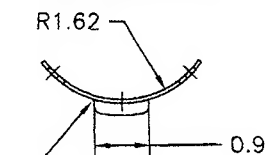
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

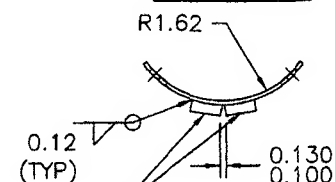


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

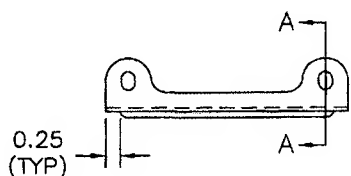
SECTION B-B



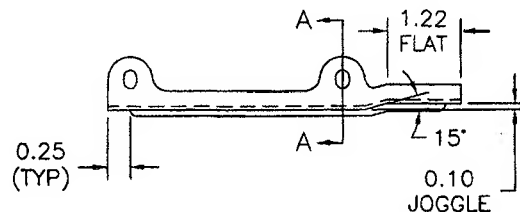
D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
07-05-08 AB
PER ECU
952

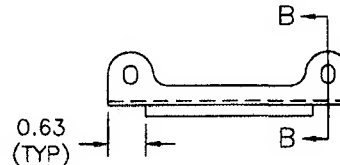
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



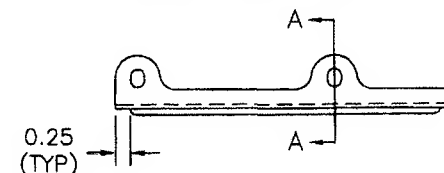
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

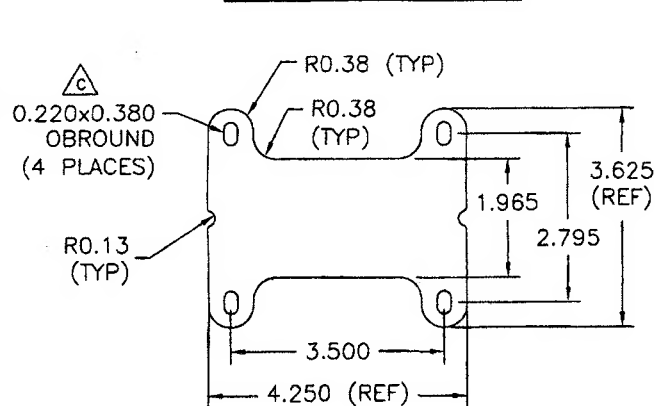
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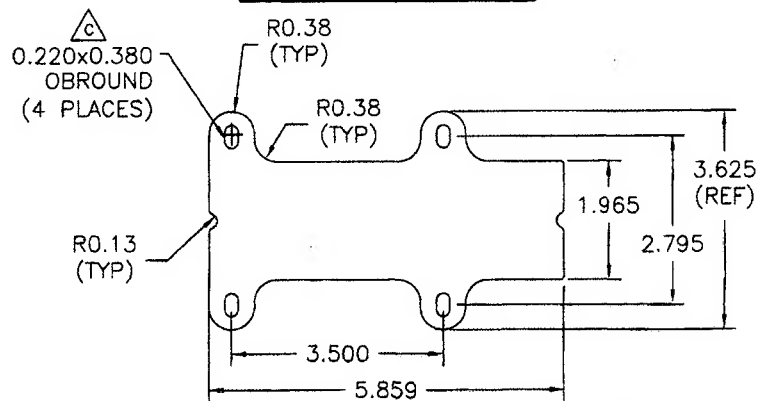
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

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PORT HADLOCK, MA

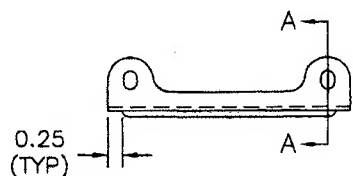
D3537-1F FLAT PATTERN



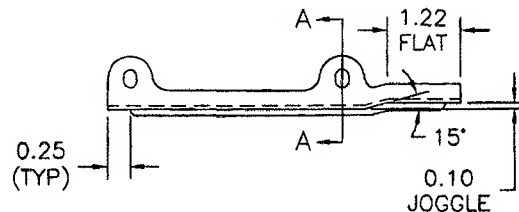
D3537-3F FLAT PATTERN



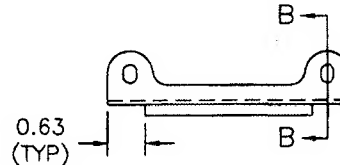
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



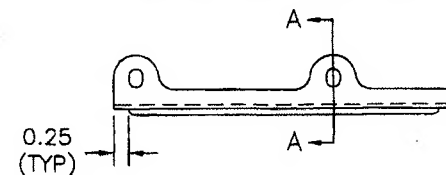
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



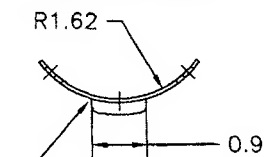
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

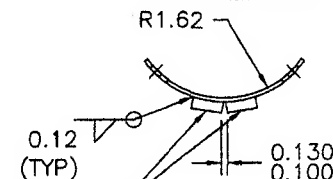


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07-05-08
PCF ELN
952

D3537-1/-3/-5/-7 WEARPAD NOTES

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DRAWING NO.	D3537	REV. C
TITLE	WEARPAD	SHEET 1 OF 1
		SCALE 1:2

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